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08560 Manlleu (ES)**(54) LIQUID ENZYME DOSER**

(57) Liquid-enzyme-dosing device which consists in projecting the enzymatic liquid by injection onto the end product. Dosing is highly accurate, metered by an in-piping positive-displacement flow rate meter. Regulation of dosing is carried out using a motorized microregulation valve. Monitoring of dosing takes place in a micro-processor which combines all the functions of the apparatus.

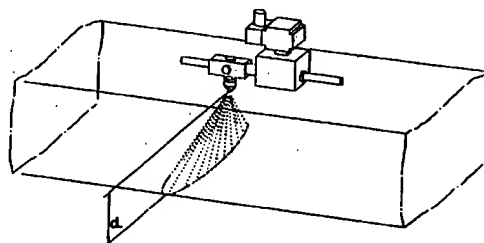


FIG. 4

EP 0 789 291 A1

EP 0 789 291 A1

Description

Field of the invention

- 5 The subject of the invention is a monobloc apparatus for dosing enzymes, for the addition, dosing or admixing of enzymes in the liquid state in the process of preparing feed, preferably post-pelletized feed.

Prior art

- 10 From the biochemical point of view the addition of particular enzymes in the manufacture of compound feed could be defined as the admixing of a substance capable of activating or facilitating a chemical reaction which allows the conversion or breakdown of a substance.

Like many other biological functions, animal digestion is the sum of a set of chemical transformations activated by enzymes which act on ingested foods.

- 15 At the present time, new animal nutrition techniques incorporate the use of various types of enzymes, making it possible to increase the nutritional value of feed by improving its digestibility and thereby achieving large yields and high conversion ratios.

- It is therefore logical to facilitate the dosing of the said enzymes in liquid form for the manufacturer of compound feed by furnishing him with an apparatus which allows him to effect the said addition correctly, with the greatest ease of installation, handling, robustness and accuracy.

20 In order to determine the type of dosing system, we ought to consider two points:

- Any enzymatic product, be it of solid or liquid type, possesses the property of being a heat-sensitive product, that is to say that, when subjected to high temperatures during the various manufacturing processes, they are to a large extent destroyed.
- The present trend of manufacturers of feed for young animals in the mainly pig and poultry sector is to produce extruded, expanded and pelletized feed (at the very least pelletized). It is in this type of feed and for these young animals that the addition of enzymes in the liquid state offers better results. Admixing the said liquids into pre-pelletized meal would destroy some of the enzymatic properties on account of the high temperatures to which they would be subjected in this phase of the manufacturing process.

- Bearing in mind that the quantities of enzymes in the liquid state to be admixed will be relatively small (of the order of 600 cc per tonne of manufactured feed) and that the entire spectrum of dosing apparatuses of the monobloc type has been devised for small reservoirs of liquid in the form of 50 - 100-l drums, the main characteristics which the said apparatuses should possess could be determined as follows:

- High-precision dosing in l/minute;
- Ease of installation and handling;
- Robustness of the plant components;
- Almost zero maintenance.

In the patent ES2003958, the proprietor, Mangra S.A., has already protected a continuous-mode system for dosing and admixing fluids in the process for pelletizing compound feeds. This system, however, was designed to work while hot during the pelletization process since the substance to be dosed, molasses, was not heat-sensitive.

- 45 Most of the dosing apparatuses currently on the market use pulsed dosing pumps, either of the plunger or membrane type. The said pumps are adjusted via a control located on the actual dosing or body unit. Verification that each pulse is equivalent to a specified rate of atomization has to be carried out via in-situ tests. This system entails the following drawbacks:

- It presupposes that each pulse determines a flow rate, without there being a flow rate meter to verify this;
- Regulation is manual, there being no automatic monitoring;
- Regular tests need to be carried out to control dosing quality.

- On the European market there are pumps similar to those used in the dosing system which is the subject of the invention, but they are built into dosing devices which lack microregulation and electronic data processing.

Likewise, known injectors have spraying angles which vary solely as a function of the working pressure and do not embrace all the sprinkling possibilities offered by the components of the enzyme-dosing system which is the subject of the invention.

EP 0 789 291 A1

Summary of the invention

The foregoing considerations lay down the guideline that the dosing system will be a continuous addition of enzymes, to be carried out after the pelletization process, using a product that has already been pelletized and chilled.

Consequently the system will consist of an admixing of enzymes which will be accomplished by utilizing the discharging of the pellet as it exits the chiller, either as it drops or during transportation.

For this purpose a specific product-flow sensor will be fitted which will advise when to begin dosing and also when to terminate it.

The dosing of enzymes will be monitored electronically in an automatic manner by a microprocessor which will combine the following functions:

- * Directly reads machine production either on the basis of the density of the product or continuous weighing;
- * Adjusts the sprinkling flow rates by actuating a microregulation valve, processing the flow rates obtained from it by means of a flow rate meter;
- * Stores and processes incidents (alarms, checks, etc.) and parameters (times, tonnes manufactured, etc.).

Detailed description of the invention

It will be necessary to determine the tonnes/hour of product transported by the conveyances so as thereby to calculate the l/minute which have to be added. (0.6 l of enzymes per tonne of product, approx.).

Dosing will be accomplished by enzyme being sprayed through an injector or injectors with one or more specific spraying angles for sprinkling the entire width of the conveyances. The working or atomization pressure will be achieved with a magnetic-drag gear pump. The rate of admixing will be regulated by a microregulation valve. The said rates will be metered with a precision volumetric gauge and displayed using a digital l/minute indicator so as subsequently to obtain their total in litres using their relevant totalizer gauge.

The preferred embodiment of the invention will now be described with the aid of the following figures:

- * Figure 1: Detail of the volumetric flow meter
- * Figure 2: Detail of the flow valve/injector body assembly
- * Figure 3: General operating diagram
- * Figure 4: Example of the arrangement of the various components incorporated.

There now follows a detailed description of the invention on the basis of the various elements of the apparatus, taken separately by means of the figures:

Figure 1:

- (1) PINION WITH MAGNETS
- (2) PINION WITH HOLLOW ORIFICES

Figure 2:

- (1) ENZYMAIC LIQUID INLET JUNCTION
- (2) ELECTRIC FLOW VALVE
- (3) INJECTOR GUIDE PIPE
- (4) INJECTOR SUPPORT
- (5) INJECTOR
- (6) AIR INLET NOZZLE

Figure 3:

- (1) ENZYME VESSEL: with monitored temperature
- (2) VALVE 1
- (3) FILTER
- (4) PUMP
- (5) MANUAL VALVE
- (6) MANOMETER 1
- (7) NON-RETURN VALVE
- (8) FLOW RATE METER

EP 0 789 291 A1

(9) MICROREGULATION VALVE

(10) VALVE 2

(11) INJECTOR

(12) VALVE 3

(13) MANOMETER 2

(14) VALVE REGULATING CIRCUIT PRESSURE

(15) MICROPROCESSOR: Monitors dosing automatically

General operating diagram (Fig. 3)

Via an in-line continuous weighing system it is possible to determine the production in MT/h of feed pellets. This data item is entered into the microprocessor (15). Starting from the tank (1) for storing the enzymatic liquid, the dose of enzyme to be admixed with the pellet is extracted as the pellets are produced. Extraction of the enzyme liquid is accomplished by means of the gear pump (4), the function of which is to maintain a constant pressure of previously filtered fluid, and suction, at the inlet of the microregulation valve (9). The said valve will be operated so as to monitor the appropriate injection rates which are constantly measured by a high-resolution flow rate meter (8) which is extremely accurate. The microprocessor (15) will be responsible for integrating these three functions. It will read the production of feed and will dose the enzymes, monitoring the microregulation valve so as to obtain an instantaneous fluid flow rate read by the high-resolution flow rate meter (8). The admixing of the enzymatic liquid will be carried out by pressure atomization, with or without the aid of compressed air, through one or more injectors (11). The planar spraying angles will be variable, with the objective of sprinkling the product homogeneously.

Non-limiting example of a preferred embodiment of the invention

Figure 4:

This figure describes a set-up and arrangement of the component elements of the apparatus by way of a non-limiting example of an embodiment of the invention.

(1) APPARATUS SUPPORT BASE PLATFORM

(2) ELECTRICALLY-OPERATED VALVE/ATOMIZATION INJECTOR ASSEMBLY

This assembly is detailed in Figure 2. The on or off electrically-operated valve for injecting the fluid is a two-way valve which is normally closed and of sufficient bore to prevent possible throttling of the flow.

The injection body is formed by a flat spraying nozzle with tapered edges for obtaining high uniformity of distribution (spraying angles of between 25 and 110°). The spraying tips are of the interchangeable type. The spraying rates, evaluated with H₂O, are shown in the table below:

PRESSURE	1 bar	2 bar	3 bar	4 bar	5 bar
C1 0050	0.11	0.16	0.20	0.22	0.25 l/min
C1 01	0.23	0.32	0.39	0.45	0.50 l/min

The electrically-operated valve/injector assembly has a stainless-steel pipe-like extension with fastening facility (Figs 2, 4) so that the various sprinkling sections can be displaced and adjusted in each particular case.

The selection of dosing injectors will be based on two types, one for dosings of the order of from 100 to 250 cc/minute (C1 0050) and the other for dosings of from 250 to 500 cc/minute (C1 01).

The fitting of one or the other will logically depend on the quantity, in tonnes per hour, of finished product taken away by the conveyance and to which injection will be applied.

The selection of one or the other will thus depend on the quantities or margins thereof which it is desired to dose.

For example, assume a conveyance of finished product produced at a rate of 15MT/h and that the quantity of enzyme liquid is to be 0.6 l per tonne.

* $0.6 \times 15 = 9 \text{ l/h} = 150 \text{ cc/minute}$. In this case, C1 0050 will be used.

EP 0 789 291 A1

Assume instead a conveyance of finished product produced at a rate of 30 MT/h, and that the quantity of enzyme liquid is to be 0.69 l per tonne.

* $0.69 \times 30 = 20,700 \text{ l/h} = 345 \text{ cc/minute}$. In this case, C1 01 will be used.

In either case, having determined the rating of the injector, dosing will be carried out by increasing or decreasing the flow rate using the microregulation valve.

(3) ELECTRICAL POWER BOARD

The said board is located in the same base platform of the apparatus. It will contain all the possible connections of the elements to be monitored, including the monitoring link with the front panel, or the link to a hypothetical panel or remote control board, as the case may be. The said board will contain:

- Terminals for the mains inlet connection;
- Magnetothermal protection and contactor for the admixing pump;
- Control relays and isolating transformer;
- Connection terminals for: minimum drum level, volumetric flow rate meter, injection electrically-operated valve and automatic dosing connection;
- All of the above electrical equipment will be mounted in a self-extinguishing, double-insulation modular casing with high resistance to chemical agents and high temperatures (150°C) and manufactured in reinforced polyester.

(4) DOSING CONTROL MICROPROCESSOR

This is the monitoring part of the dosing apparatus. Just like the entire assembly, this will be situated as closely as possible to the points of injection. If by chance there is a remote control board, it would be located according to the choice of the operator responsible for monitoring dosing. The contents of the control board correspond with the functions to be undertaken by the microprocessor and which are as follows:

- Emergency breaker switch and apparatus-on switch;
- Illuminated on and off buttons for the admixing pump;
- Buttons for relieving/throttling the microregulation valve. Illuminated indicator buttons for dosing alarms;
- Illuminated indicator warning of minimum level in the fluid container;
- Litre totalizer gauge;
- Indicator/monitor of l/min with monitoring of maximum and minimum dosing alarms;
- If there is remote control, all of the control elements will be placed in a monobloc metal cabinet, its sides being constructed from a single piece and bent double. Painted outside and inside with textured polyester-epoxy resin.

COUNTING AND TOTALIZING OF DOSING

Any HIGH-PRECISION flow rate gauge or meter (FLOW RATE METER) of the OVAL GEAR or COG type requires high resolution since, when metering the fluid flowing through, a PULSE STRING of the order of 2000 to 2300 PULSES is obtained for each litre of product.

All of this flow rate metered in the form of PULSES will have to be translated and reflected in an analytical form as instantaneous quantities of cc per minute, as will its total in litres.

* Flow rate meter pulse converter with instantaneous indication of flow rate.

The pulses emitted by the flow rate meter will have to be forwarded to a frequency/current (mA) converter, monitored by the microprocessor which will fulfil a dual function:

FUNCTION A: Converting the pulse frequency into a variable current of from 0 to 20 mA which correctly processed we shall obtain a reading of INSTANTANEOUS FLOW RATE IN CC/MINUTE.

FUNCTION B: In parallel with the above function there is an optocoupled output signal of identical frequency to the frequency of the input. It is then possible with these pulses to count them later in conjunction with the density correction factor and TO TOTAL THEM IN LITRES of dosing.

* Dosing totalizer and its programming.

After processing by the (optocoupled) CONVERTER, the frequency of the pulses generated by the flow rate meter when the fluid passes through it needs to be received by the totalizer.

EP 0 789 291 A1

Any precision meter, such as the one under discussion, generates a large quantity of PULSES/LITRE. If we were interested in monitoring a dosing in KILOGRAMS, it would be necessary to multiply the said pulse frequency by a correction factor directly related to the density of the fluid so as thereby to translate litres into kilograms.

This is the chief function of the DOSING TOTALIZER. It consists of a programmable gauge/totalizer with a correction scale or factor (pulse divider) which makes it possible to convert PULSES/LITRE into PULSES/KILOGRAMS.

The said gauge possesses a wide spectrum of processes and can be programmed for various actuation areas.

* Indication of instantaneous flow rates.

Use will be made of a digital indicator with two alarm preselects or levels to display the flow rates, in CC/MINUTE, which will be dosed at any time in the enzyme-addition process.

The signal input will be from 4 to 20 mA with a digital read out of between 0 and 1000 CC/MINUTE. Its two alarm outputs, correctly preselected, will give two alarm levels.

Assume that it is desired to dose 630 cc/minute and establish dosing error margins of 20 cc/minute and therefore set the minimum permitted dosing alarm preselector at +610 and that for the maximum dosing alarm at +650.

The permitted error will be with these +/-20 cc dosing levels.

(5) FLOW RATE METER

The said meter operates on the principle of positive-displacement volumetric metering in piping. It consists of two oval wheels housed in a chamber through which the liquid flows. These oval wheels are gears of oval outline which are forced to rotate continuously through the thrust of the liquid flowing through, allowing the passage of cyclic volumes for each revolution of the said wheels (Figure 1).

The accuracy of metering, using this system, is one of the highest which is presently available in the market given, additionally, that it is virtually unaffected by the variation in the density or in the viscosity of the fluid. With the subject of the invention an accuracy of $\pm 0.2\%$ of the actual volume is obtained for any condition of the fluid and any metering rating.

The sensor element (meter) will be placed in the piping and, by means of a static pulse generator placed against the body, it will deliver signals of variable frequency, depending on the flow rates, to an electronic receiver placed remotely which, in actual fact, is the element for reading the volume which has flowed through. The magnetically generated pulses (IMP/L) are received, processed and converted into a user-friendly read-out via gauges providing a direct indication of flow rate in real time.

To summarize, it could be said that the said meter possesses the following general technical characteristics:

- HIGH ACCURACY;
- MINIMUM LOSS OF HEAD ON ACCOUNT OF THE ACTUAL CONSTRUCTION;
- VERSATILE/COMPATIBLE, being unaffected by vortices or turbulence in the piping and therefore requiring no straight sections and capable of being placed immediately at the outlet of a pump.

It has a 0.5-50 litres/hour metering rating, with maximum working temperatures of -10°C to $+70^{\circ}\text{C}$, a working pressure of 5 kg/cm^2 and an accuracy of $\pm 0.5\%$ of actual volume.

(6) PRESSURE INDICATING MANOMETER

This will be located on the front panel of the dosing cabinet and joined to the admixing piping with a flexible joint. It is a manometer with glycerine bath, the best choice in pressure metering applications with rapid and large changes of head, and pump vibrations and pulsations. It has a metering rating of 0-10 bar.

(7) ADMIXING ELECTROPUMP

Magnetic-drag rotary gear pump devised uniquely and exclusively for viscous and chemically abrasive liquids, linear dosings; low noise level and highly robust. It has a maximum working pressure of 7-12 bar.

(8) SPRAYING FILTER

This is an impurities filter, for fluid dosing, giving high performance in terms of reliability and accuracy. It is essential in this type of dosing to filter out the impurities which could to a large extent impair the FLOW RATE METER and also the ATOMIZATION INJECTORS. It offers the option of easy and rapid exchange of the filtering MESH with four types of pitch. It also possesses high strength at the 16-20-bar working pressure.

EP 0 789 291 A1**(9) MINIMUM LEVEL and MACHINE TRANSFER**

Level detector with magnetic float. This is constructed from two thin leaves of ferromagnetic material separated by a narrow gap and hermetically enclosed in a glass ampoule filled with inert gas so as to avoid contaminants and oxidation of the contacts. Maximum pressure 50 bar.

(10) FLEXIBLE SPRAYING HOSE

The flexible spraying hose will be joined to a rigid PVC straight which must have a non-return valve at its extreme end. The hose is reinforced with polyester mesh. Maximum nominal pressure 10 bar; maximum temperature + 70°C.

(11) FLEXIBLE ADMIXING HOSE**(12) ELECTRICAL CONNECTION CABLES**

The VVfV/RVfV-type hoop-iron armoured cable is the appropriate cable when flexibility criteria are not of maximum importance but where the level of mechanical protection of the cable against knocks, squashing, rodents, etc., is fundamental. This cable has crosslinked polyethylene insulation thereby permitting greater power transmission for equal cross section. The electronic signal leads are made from screened, flexible cable with characteristics similar to the previous type.

(13) GALVANIZED-STEEL PIPING/CLAMPS

Galvanized-steel lengths of straight pipe of greater diameter than that of the injection hose will be supplied for the installation of the admixing piping on the atomization body so as to produce a two-pipe gauged system, the said lengths being fastened, until they reach the atomizing element, with their relevant clamps, either welded to metal supports or fastened to structural walls using nails.

(14) MANUAL FLOW VALVE

The purpose of this is to create a bypass to provide the option for quality control of dosing using the sampling taps.

(15) MICROREGULATION VALVE

The purpose of the apparatus is mainly concerned with the addition of a specific quantity of ENZYMATIC LIQUID in cc per minute. The said quantities will vary between 100 and 300 cc/minute. To achieve this requires an injection pump which gives a constant working pressure, accurate volume metering with which the said quantities can be measured and, of course, a MICROREGULATION valve capable of setting the appropriate amount, expressed as grammes, of injection for each application.

Control of the said valve may be motorized so that it can be driven remotely.

Regulation by rotary control of up to 20 actuator turns, controlled by a motorized positioning actuator. Maximum working pressure 5000 psi. Temperature range -29°C - +121°C.

(16) SPRAYING PIPE/NON-RETURN VALVE ASSEMBLY

In order to facilitate the process of discharging the containers or drums and to prevent possible problems which might arise through twisting or excessive mobility of the spraying tip, a straight and rigid length of PVC spraying piping has been constructed, the relevant non-return valve being screwed onto its end. This valve is of the foot type in order to keep the piping full for correct dosing. Essential for the type of flow rate meter employed in the said plant. Maximum temperature 240°C.

(17) AIR FLOW ELECTRICALLY-OPERATED VALVE

This is three-way, normally closed, with a working temperature of -10 - +140°C.

(18) AIR PRESSURE REGULATOR

Membrane which stabilizes the regulated pressure (0-4 bar) when the line pressure varies. High flow rate with restricted pressure drop. Rapid release of excess pressure. Maximum inlet pressure 13 bar. Maximum service temper-

EP 0 789 291 A1

ature 50°C.

(19) AIR PIPING

5 Nylon pipe which withstands high air pressures.

(20) SAMPLING TAP

10 The fitting of sampling taps is essential for any type of dosing in order to carry out the relevant quality controls on the quantities added as well as on the extraction of product specimens. BALL VALVES are fitted for the said function. These will be actuated manually so as to facilitate processes for taking specimens, calibrations and replacement of any elements in the piping. Maximum pressure 1000 psi, maximum temperatures -25°C - +232°C.

(21) MINIMUM VESSEL LEVEL

15 This is an indicator of the minimum level of pure liquid undiluted, enzymes in the vessel.

(22) CHARGING PUMP

20 The function of this is to permit the transfer of pure enzyme from the initial vessel into the dilution tank.

(23) FLEXIBLE CHARGING HOSE

25 The enzyme may obviously be dosed directly in the desired concentration, so the intermediate dilution tank and the attendant charging and level control systems must therefore be interpreted as an optional addition to the apparatus. In general, Figure 4 shows an embodiment of the invention which must be taken in its widest context, without the said example serving as a restrictive interpretation of the underlying inventive principle.

Claims

- 30
1. Apparatus for dosing enzymes in the liquid state, characterized in that it comprises:
 - one or more thermoregulated vessels which contain concentrated or dilute enzyme liquid, with indicators of minimum level
 - 35 - a device for extracting the enzyme liquid from the vessel or vessels which contain it
 - a microregulation valve
 - an extremely accurate high-resolution flow meter
 - a displaceable and adjustable injection device for variable-angle spraying
 - an electronic device for monitoring dosing governed by a microprocessor.
 - 40 2. Enzyme-dosing apparatus according to Claim 1, characterized in that the device for extracting the enzyme liquid from the vessel or vessels which contain it is preferably a gear pump capable of maintaining a constant fluid pressure in the dosing circuit and preferably at the inlet of the microregulation valve.
 - 45 3. Enzyme-dosing apparatus according to Claims 1 and 2, characterized in that the gear pump of the extraction system consists of a magnetic-drag electropump specifically for viscous and chemically abrasive liquids, which has a maximum working pressure in the range of 7-12 bar.
 - 50 4. Enzyme-dosing apparatus according to Claim 1 to 3, characterized in that the device for extracting the enzymatic liquid has an associated filtration system.
 - 55 5. Enzyme-dosing apparatus according to Claim 4, characterized in that the filtration system consists of an interchangeable mesh with a pitch size of between 0.5 and 1.2 mm, with high strength at working pressures of 16 bar and at 20°C.
 6. Enzyme-dosing apparatus according to Claim 1, characterized in that the microregulation valve consists of a precision motorized valve which can be adjusted through rotary control of up to 20 turns per actuator, with a maximum working pressure of 5000 psi and a working temperature range from -29°C to +121°C.

EP 0 789 291 A1

7. Enzyme-dosing apparatus according to Claim 6, characterized in that the microregulation valve can be operated by remote control.
8. Enzyme-dosing apparatus according to Claims 6 and 7, characterized in that the microregulation valve works at an enzymatic liquid-dosing rating which varies between 100 and 300 cc/minute.
9. Enzyme-dosing apparatus according to Claim 1, characterized in that the flow rate meter is a positive-displacement flow rate meter/gauge with a metering rating of 0.5-50 l/h, which operates at a maximum working pressure of 5 kg/cm² and a temperature rating of -10°C to +70°C.
10. Enzyme-dosing apparatus according to Claim 9, characterized in that the flow rate meter comprises a series of pairs of oval cog wheels arranged in piping traversed by the fluid to be metered, which move in a rotary and continuous manner through the thrust of the fluid flowing through, generating a series of electrical signals which are sent to a frequency/current (mA) converter.
11. Enzyme-dosing apparatus according to Claims 9 and 10, characterized in that the flow rate meter offers an accuracy of $\pm 0.2\%$ of the actual volume, being unaffected by the density or viscosity of the fluid or by vortices or turbulence in the piping itself.
12. Enzyme-dosing apparatus according to Claim 1, characterized in that the injection device comprises:
 - Three-way air-flow electrically-operated valve, preferably closed, with a working temperature rating which varies between -10°C and +140°C.
 - Air-pressure regulator with a rating of 0-4 bar
 - Two-way enzymatic liquid injection on and off electrically-operated valve, preferably closed, with a temperature rating and working pressure of -30°C to +140°C and 0.3 to 20 atmospheres, respectively.
 - Gaseous-fluid pneumatic-atomizing injectors with interchangeable nozzles with tapered edges which produce a planar spray, with a flow rate of between 0.1-0.5 l/min and spraying angles of between 25° and 110°.
13. Enzyme-dosing apparatus according to Claim 12, characterized in that enzymatic liquid can be supplied to the injector under pressure or by gravity.
14. Enzyme-dosing apparatus according to Claim 1, characterized in that the microprocessor for electronic monitoring of dosing comprises the following functions:
 - flow indicator which receives the signals from the flow rate meter
 - preselection with control of regulation
 - gauge/totalizer with reset to zero and l/kg correction factor
 - error tracking
 - relays for opening and closing the microregulation valve
 - selection of manual or automatic mode of working
 - maximum and minimum flow rate alarms
 - storage and processing of data and incidents: time, MT manufactured, checks, etc.
 - minimum level of enzymatic liquid in the vessel or vessels
 - switching-on/off of the entire apparatus
 - l/kg corrector
 - readout of pellet production to be covered by in-line weighing.
15. Application of the enzyme-dosing apparatus described in Claims 1 to 14 for the continuous supply of enzymes to chilled products after they have been subjected to an extrusion, expansion and pelletization process.
16. Application of the enzyme-dosing apparatus according to Claim 15 to the production of pelletized products in the manufacture of feed or food for animals.
17. Application of the enzyme-dosing apparatus according to Claim 15 to the production of pelletized products in the manufacture of drugs.
18. Application of the enzyme-dosing apparatus according to Claim 15 to the production of pelletized products in the manufacture of fertilizers or manures.

EP 0 789 291 A1

19. Application of the enzyme-dosing apparatus according to Claim 15 to the production of pelletized products in the manufacture of foods for adults or children.

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EP 0 789 291 A1

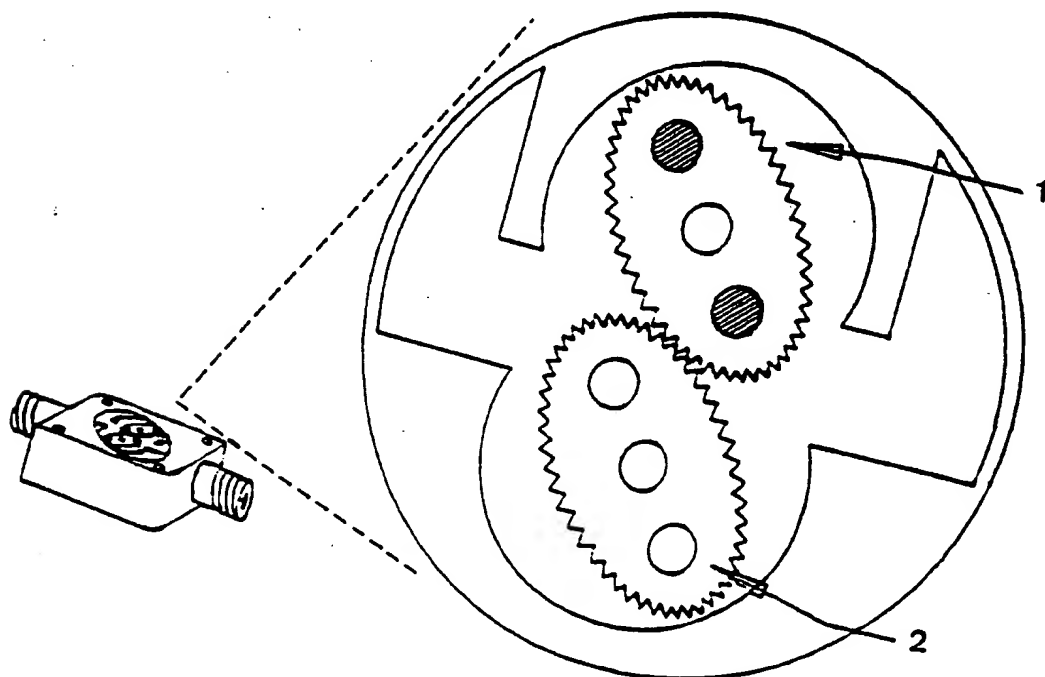
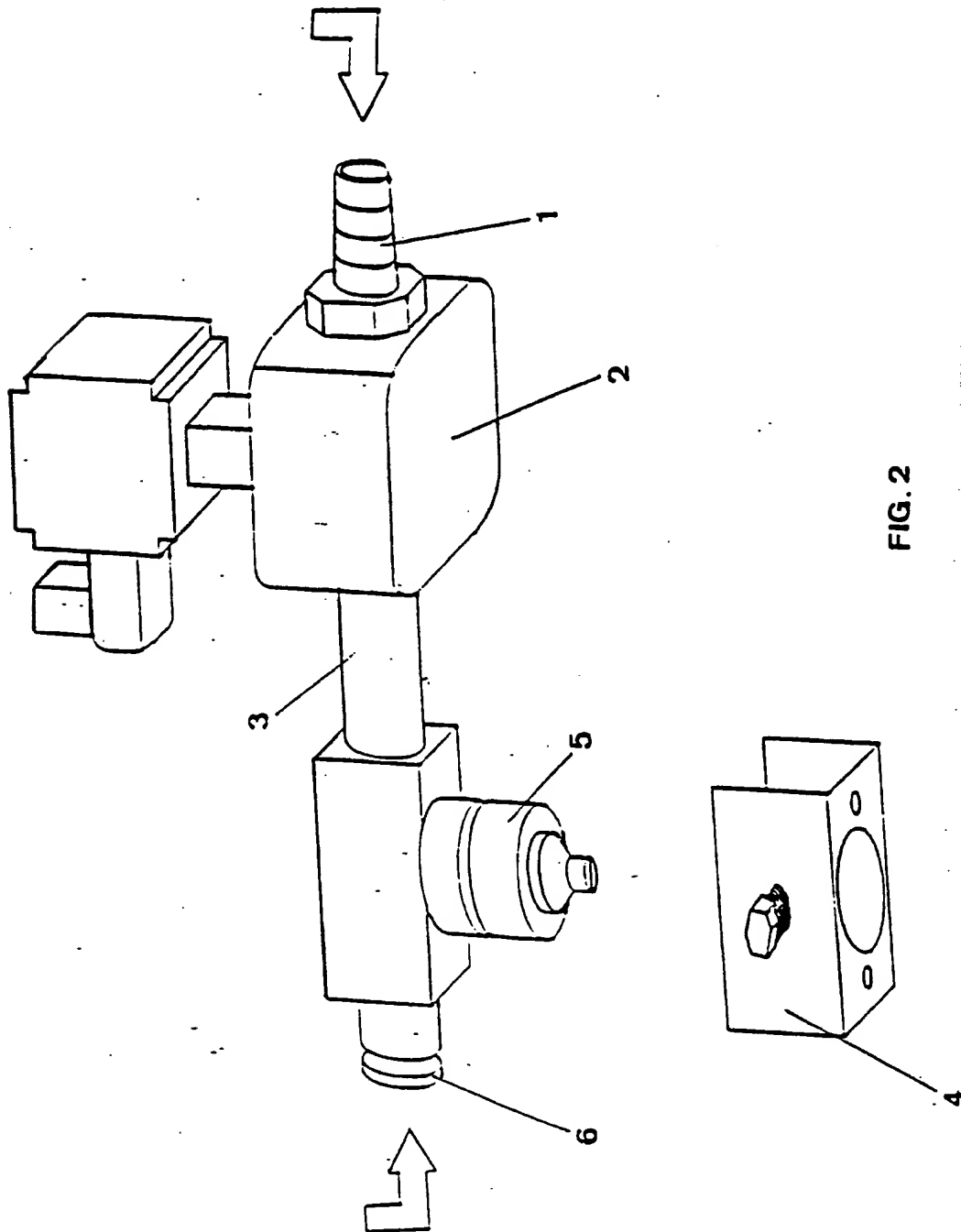


FIG. 1

EP 0 789 291 A1



EP 0 789 291 A1

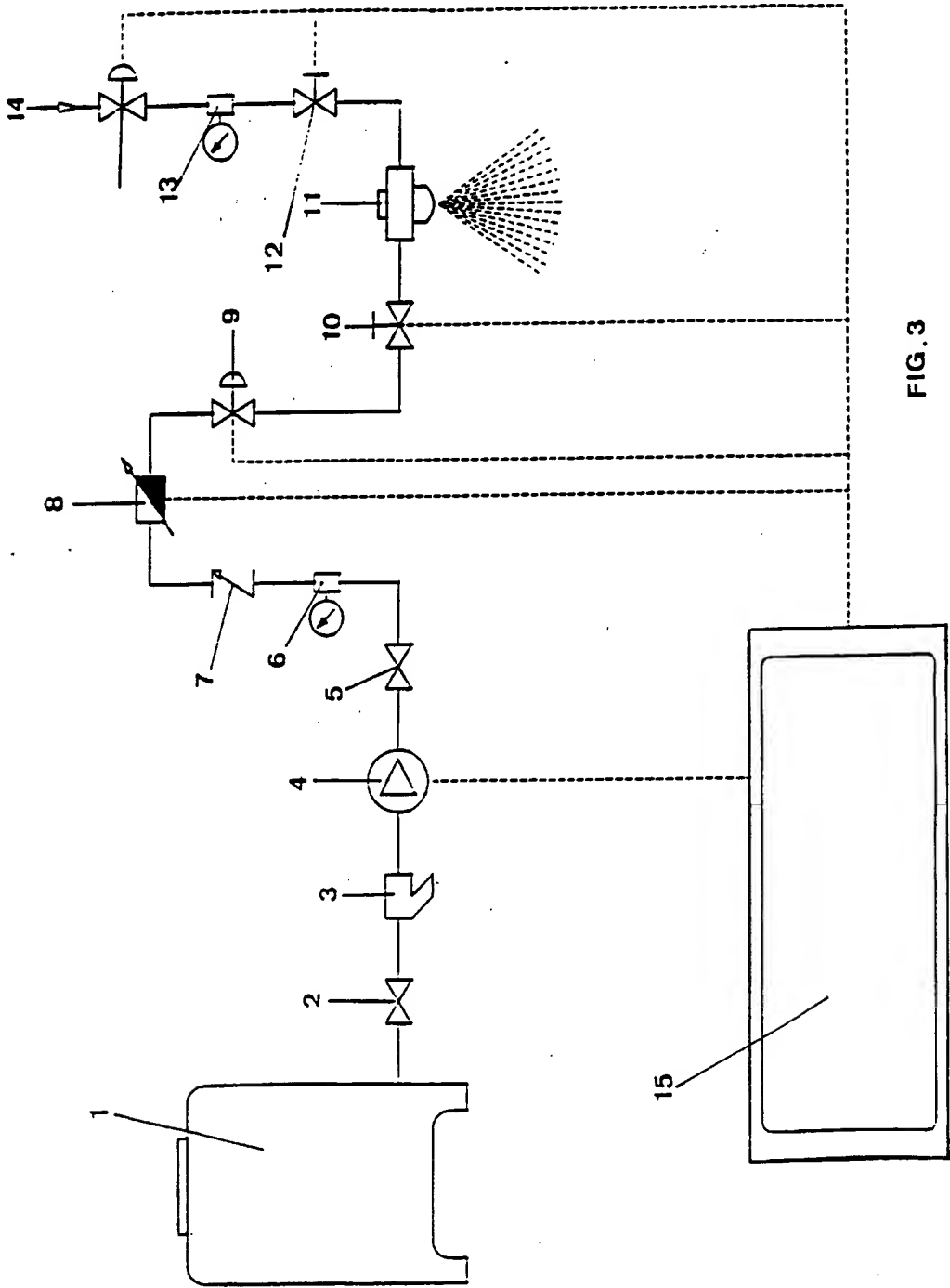


FIG. 3

EP 0 789 291 A1

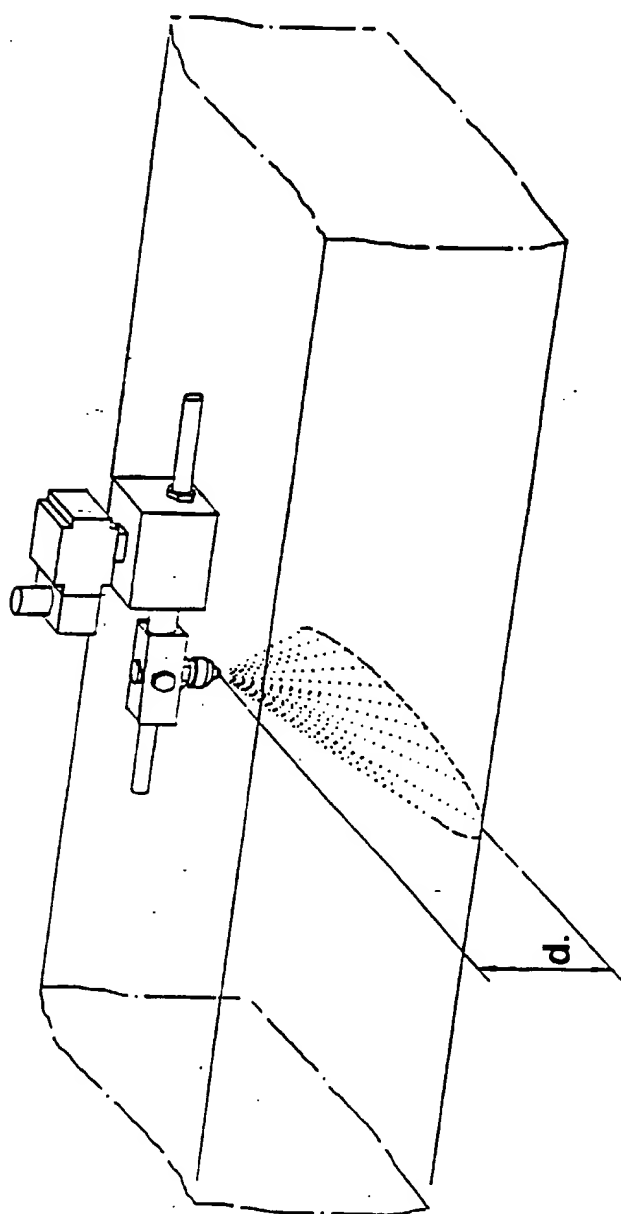


FIG. 4

EP 0 789 291 A1

INTERNATIONAL SEARCH REPORT

International application No.

PCT/ES 96/00127

A. CLASSIFICATION OF SUBJECT MATTER

IPC6 G05D 11/00 A23K 1/65

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC6 G05D A23K

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where applicable, search terms used)

CIBEPAT; WPIL; EPODOC

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	ES 2003958 A (MANGRA, S.A.) 1 December 1988, (1.12.88) cited in the application see the whole document	1-4,6
A	FR 2628340 A (AZT AGROZOOTECNICA SA), 15 September 1989, (15.09.89), see figure 1, see page 2, line 18 - line 35 see abstract	1-4,6
A	GB 1572761 A (HENKEL KGAA) 6 August 1980, (06.08.80) see the whole document	

☐ Further documents are listed in the continuation of Box C.☒ See patent family series.

* SYMBOLS characterizing the documents:

"A" documents defining the priority claim of the art which is not considered to be of particular relevance

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"L" documents which may have priority claims or which is cited to establish the publication date of another document or other technical features (as indicated)

"O" documents referring to an other document, the substance of which is not relevant

"T" documents published prior to the international filing date but in the name of the priority claimant

"X" later document published after the international filing date or priority claim but not in conflict with the documents but cited in connection with the substance of the invention

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"&" document identical to the same claim family

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Information on patent family members

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